

Work Order ID 63586

Thursday, November 04, 2010 1:06:39 PM

Page 1

Item ID: D2939-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle RH In, 206

Start Date: 11/4/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 11/4/2010 Start Qty: 6.00



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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

enr 10/11/30

6 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=) M 10/12/02

x6 0

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M115951

START TIME:

10:15

OVEN TEMPERATURE:

FINISH TIME:

10:45

6 BL 10-12-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

=) Jbl 10/12/01



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 428A

0.00



Packaging

Memo

0.00

Packaging

10/12/01 sl (6x)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/02 JF
UMF
10-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 04, 2010 1:06:43 PM

Page 1

Work Order ID: 63586

Parent Item: D2939-2

Parent Item Name: Saddle FH In, 206




Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001  Saddle Billet		Manufactured	No			100	Each	2.0000	1	6			

Location

Loc Qty

Loc Code

MAT40

2

61385

2

B 63537 x6

amt 10/11/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	63586
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140	Verifier all	.124	.124	.124	.124	.124
B	0.100	0.140	Rad - 02	.125	.125	.125	.125	.125
C	0.100	0.140		.125	.125	.125	.125	.125
D	0.210	0.230		.222	.222	.222	.222	.222
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.510	.510	.510	.510	.510
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.259	.259	.259	.259	.259
L	0.312	0.317		.316	.316	.316	.316	.316
M	0.235	0.240		.236	.236	.236	.236	.236
N	0.100	0.140		.115	.115	.115	.115	.115
O	0.540	0.560		.553	.553	.553	.553	.553
P	0.490	0.510		.507	.507	.507	.507	.507
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.250	.250	.250	.250	.250
T	0.100	0.180		.127	.127	.127	.127	.127
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270	indicator - 9	1.261	1.261	1.262	1.262	1.262
Y	1.565	1.585	indicator	1.576	1.576	1.577	1.577	1.577
Z	0.178	0.198	Rad 88	.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	10.11.30
Audited by:	<i>[Signature]</i>	Date:	10/11/30
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 63584
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140	Verier all	.124				
B	0.100	0.140	MR-02	.125				
C	0.100	0.140		.125				
D	0.210	0.230		.222				
E	1.245	1.255		1.250				
F	1.245	1.255		1.250				
G	2.495	2.505		2.500				
H	0.510	0.515		.510				
I	1.572	1.582		1.577				
J	2.495	2.505		2.500				
K	.257	0.262		.259				
L	0.312	0.317		.316				
M	0.235	0.240		.236				
N	0.100	0.140		.115				
O	0.540	0.560		.553				
P	0.490	0.510		.507				
Q	3.715	3.725		3.720				
R	2.720	2.760		2.740				
S	0.240	0.270		.250				
T	0.100	0.180		.127				
U	1.625	1.635		1.630				
V	1.362	1.372		1.367				
W	.316	0.321		.316				
X	1.250	1.270	indicator AD	1.261				
Y	1.565	1.585	"	1.576				
Z	0.178	0.198	Red gauge	.188				
AA								
AB								
AC								
AD								

Accept/Reject

Measured by: *[Signature]*

Audited by: *[Signature]*

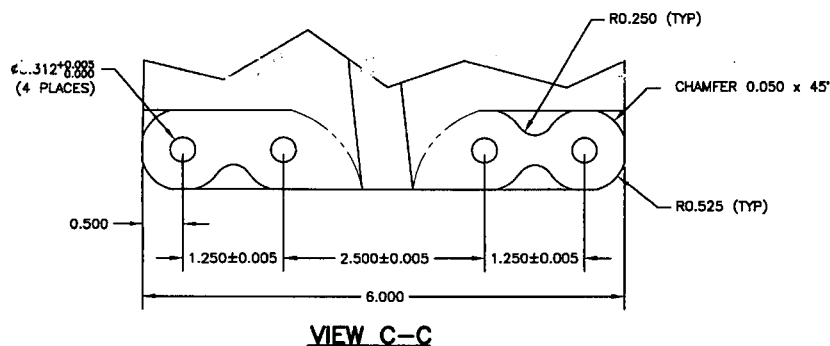
Prototype Approval: N/A

Date: 10-11-30

Date: 10/11/30

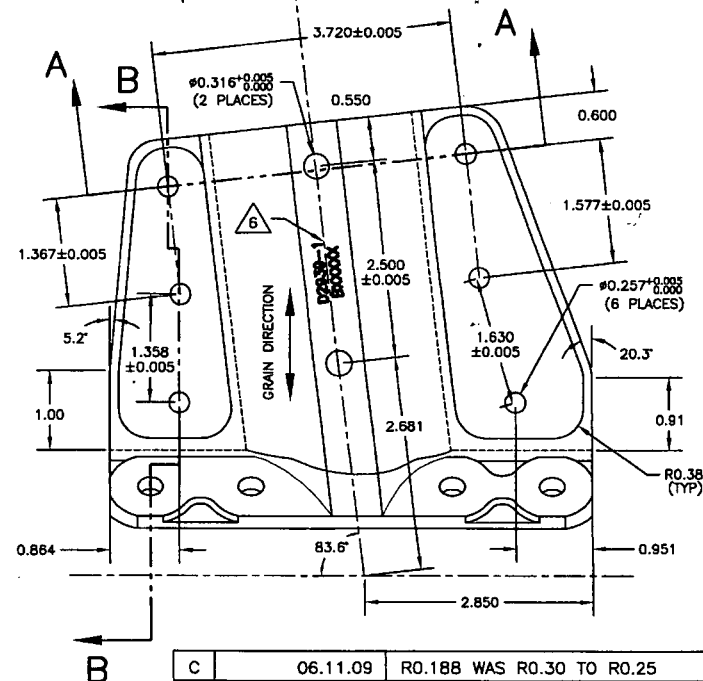
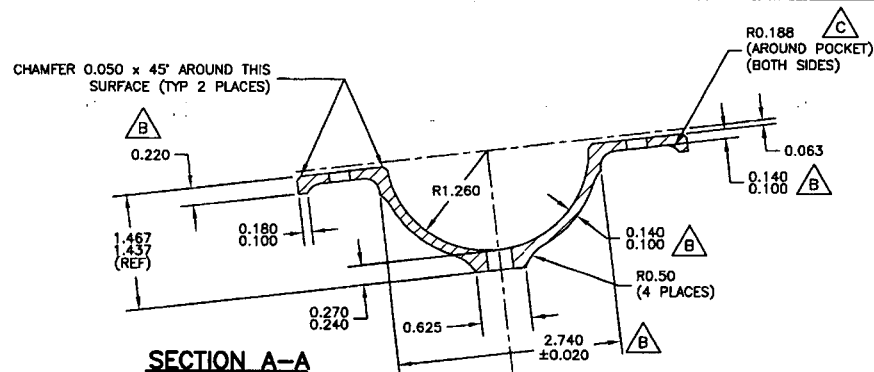
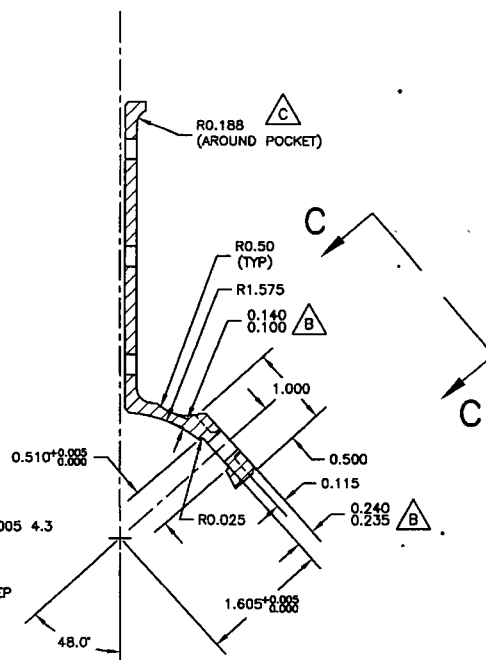
Date: N/A

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D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE
		DART DART AEROSPACE USA, INC.
		REV. C
		D2939
		SHEET 1 OF 1
		SCALE
		2:3

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 SUBJECT TO APPROVAL

WITHOUT NOTICE
 WORK ORDER
 NO. 63586
 2810-11-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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